							\	~		
Work Order ID 64550 Wednesday, December 08, 2010 10.	:12:13 A						-			Pag
Item ID: D3315-5 Revision ID: Item Name: Wearplate			Accept					Setup	Start Stop	
Start Date: 12/8/2010 Star	t Qty: 3.00 'd Qty: 3.00			Cust Item Customer:					•	
Approvals: Process Plan: QC:	. / 🖰	ate: <u>/0/2-8</u> ate:	Tooling: SPC (Y/N):)ate:]	Run	Start Stop	
	ation ription	-	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Insp. Number Stamp
Draw Nbr Revision N	Nbr									
D3315 Rev B										
Waterjet FLOW CNC Waterjet	WATER JET Memo 1-Cut as per Dwg Deburr if necessar		0.00 0.00 \$\infty \text{Prog Rev:}	B 02-			181	61-0	-22	(3)
110 QC2-	Inspect parts off machin	•	0.00				<u> </u>	<u>, 10-1</u>	ક~ક	<u>ن</u>
QC Quality Control	Мето		0.00							
120 QC8-	Inspect parts - second cl	neck	ری/	123			\(\) \(\) \(\	<u> </u>		

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W/O:				RK ORDER CHA	NGES				Approval	Approval
DATE	STEP	PRO	OCEDURE CHAN	GE		Ву	Date	Qty	Chief Eng / Prod Mgr	QC Inspector
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Part No		PAR #:								
	Re	solution:	Disposition	•	QA	: N/C Cle	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFOR	RMANCE	(NCR	1)			
DATE	Description of NC		Corrective Action Section B			<u> </u>	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	•		Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 64550

Wednesday, December 08, 2010 10:12:13 A



Page 2

Item ID:

D3315-5

Accept



Setup Start



Revision ID:

Item Name:

Wearplate

Start Date:

Required Date: 12/22/2010

12/8/2010

Start Qty: 3.00

Req'd Oty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Date:_____

Tooling:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date:

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Run

Start

Stop

Reject Insp. Number Stamp

130

Sequence ID/

Work Center ID

Brake NC

Brake NC

NC BRAKE

Operation

Description

1- Form using DT8751 Die as per Dwg D3315Rev: B DT8179 Die as per Dwg D3315Rev: B

140

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

Memo

150

Large Fab

Large Fab

Memo

0.00

0.00

EL 11-1-13

Large Fab

	1									
W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PROG	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cat	egory:	NCI	R: Yes N	lo DQA :	:	_ Date: _	
	R	esolution:	Dispositi	on:	QA	N/C Clo	sed:		Date:	
NCR:		V	ORK ORI	DER NON-CONFORM	IANCE	(NCR)				
DATE	OTED	Description of NC			ction B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	n C	Chief Eng	QC Inspector
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Work Order ID 64550

Wednesday, December 08, 2010 10:12:13 A



Page 3

Item ID:

D3315-5

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Wearplate

12/8/2010

Start Qty: 3.00

Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Required Date: 12/22/2010

OC:

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**

0.00 uloch3 Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Memo

Memo

170

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

180

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112588

OVEN TEMPERATURE:

0.00

3 Bl 11-01-13.

Powder Coating

W/O:			WC	ORK ORDER CHAN	GES		-			
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR	t: Yes N	o DQ /	A :	Date:	
	Re	esolution:	Dispositio	n:	QA:	N/C Clos	sed:		Date:	
NCR:	; ;	,	WORK ORD	ER NON-CONFORM	MANCE	(NCR)				
DATE	STED Description of NC		Corrective Action Sec				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 64550

Wednesday, December 08, 2010 10:12:13 A



Page 4

Item ID:

D3315-5

Accept



Date:

Setup Start





Revision ID:

Item Name:

Wearplate

Start Date:

12/8/2010

Start Qty: 3.00

Required Date: 12/22/2010

Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

200

Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3315-5, B/N: BXXXXX□For Product Eligibility see PDA04-17□and

Stock Location: 4964

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Close-pull on alo 64556

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 03315-5 PAR #: Fault Category: Small Fab NCR: Yes No DQA: Date: 11.01.14

Resolution: rework Disposition: rework QA: N/C Closed: Date: 1/3/7

NCR: 6	{220	W	ORK OR	DER NON-CONFORMANCE	(NCR)			•
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
11 101 let	# 140	Found at slop # 200 when Pulling For P Kits + MAT all OLY x3 were bent + INSTRECTOR worms. Parts should be -6 not -5>.	bestons	Perdahir Perdahiry as As -6 wear Plates D3315-6 B64550 Afg +3	101/19		LOYUUZ	Morphy
		R.C. Dy was ocad wring and inspector incretly. LOA ATTISPECTOR repolitional error yes	1051W2	<u> </u>	Mark		posiuiz.	Solly
		D3315-5		with close or repullion who buss b (D3315-6)				

Picklist Print

Wednesday, December 08, 2010 10:12:17 AM

Work Order ID: 64550

Parent Item:

D3315-5

Parent Item Name: Wearplate



Start Jate: 12/8/2010

Required Date: 12/22/2010

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP: A□05.05.12□New issue □KJ/JLM□ IPP Rev:B As per Rev B 06-03-24 JLM

IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA	1818 B 11111 B28 11 (81 (28)	Purchased	No			100	sf	84.5250	1.8345	5.793158	3		
										B(C		7	

1010/1025 sheet 16GA

Location Loc Qty Loc Code MAT19 84.525

> 111410 84.525

W/O:			WORK ORDER	CHANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: _	Fault Category:	NCR: Yes	No DQ	A :	Date:	
	R	esolution:	Disposition:	QA: N/C (Closed:		Date: _	

CR: WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	Annroyal		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector		
				,					
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Section A Initial Action Description	STEP Description of NC Section A Chief Eng Corrective Action Section B Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Section C Section C Section C	STEP Description of NC Section A Corrective Action Section B Sign & Date Chief Eng Chi		

DART AEROSPACE LTD	Work Order:	44530
Description: Wearplate	Part Number:	D3315-5
Inspection Dwg: D3315 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

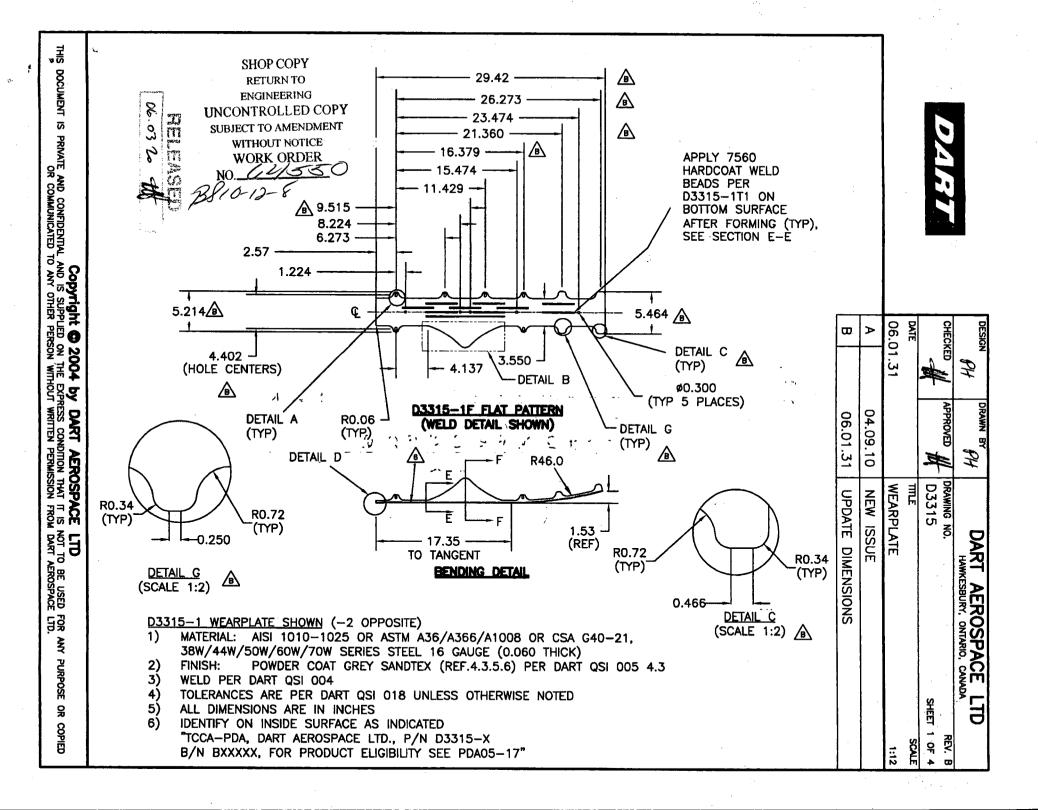
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	حد		T BO(
30.215	+/-0.010	30.215	×		7	
24.215	+/-0.010	24.715	×		7	
21.611	+/-0.010	21.6(1	8		7	
17.965	+/-0.010	17.965	bo		Τ	
16.026	+/-0.010	(6.0)6	8		T	
14.735	+/-0.010	14,735	>		T	
12.815	+/-0.010	12.815	D		7	
6.465	+/-0.010	6.465	7		7	
5.40%	+/-0.010	5:465	x		V BOX	
4.527	+/-0.010	4,525	7		ν	
3.550	+/-0.010	3,558	8		V	
5.214	+/-0.010	5.707	X		V	
Ø0.300	+0.006/-0.001	,324	K		V	
Ø0.266 x 0.575	+/-0.010	26600,579	Ø		V,	
Ø0.266 x 0.450	+/-0.010	260 4.40	9		V	
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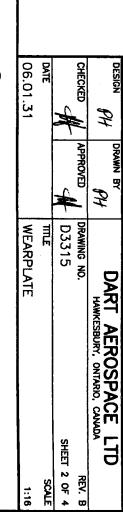
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Date:	10-17-25	Date: 10/13/03	,	Date:	N/A
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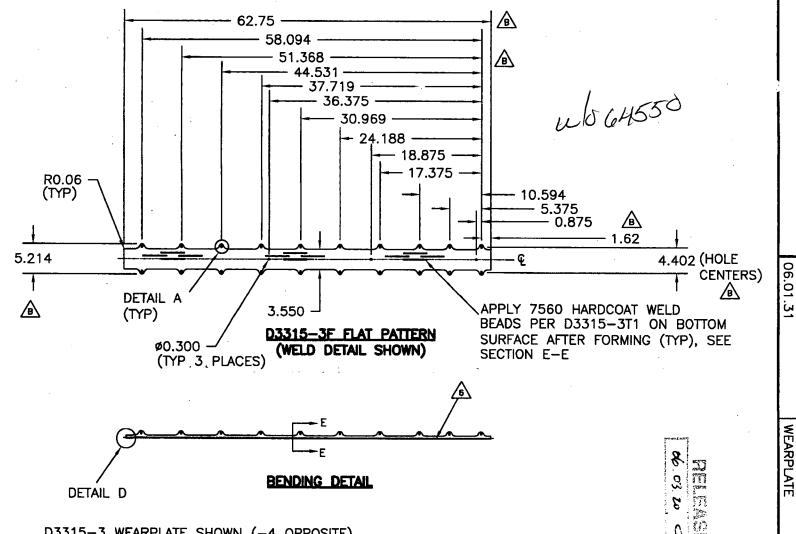
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W/O:	-		WC	RK ORDER CHANGES	3						
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _			
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DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector		
									Account of the Control of the Contro			
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D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY ON INSIDE SURFACE AS INDICATED "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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PRIVATE AND CONFIDENTIAL AND IS S
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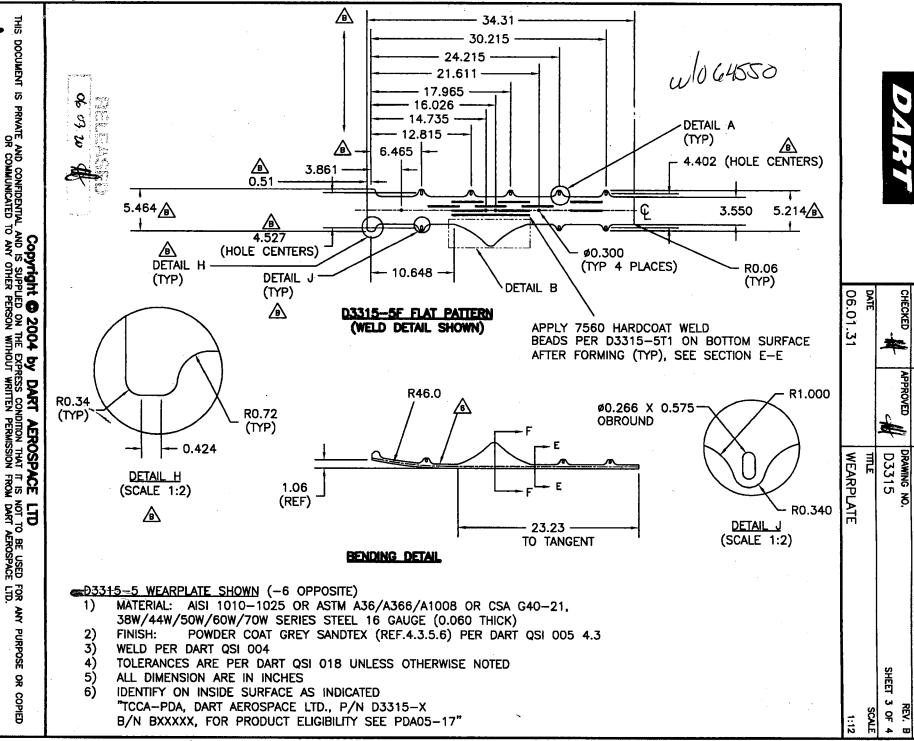
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AEROSPACE (KESBURY, ONTARIO, CANADA



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	T	Description of NC		Corrective Action Section	Verification	Approval	Approval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
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DETAIL A (SCALE 1:2) R0.34 (TYP) 06.03 20 R0.72 (TYP) wloaussd Ø0.266 X 0.450 **OBROUND** Β' 9.466 15° 0.063 JOGGLE 2.831 1.000 JOGGLE R0.83 (TYP) R10.5 DETAIL D (SCALE 1:2) (TYP) DETAIL B (SCALE 1:4) R2.00±8888 0.97 R2.00^{+0.030}_{-0.000} 1.15 16 SECTION E-E (SCALE 1:2) 59* 1.21 0.56 (TYP) R0.75 -2,-5,-6 ONLY) R1.00 HARDCOAT WELD

BEADS (TYP) 0.063 TO 0.125 HIGH

SECTION F-F

(SCALE 1:2)

DOCUMENT ᅜ

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PURPOSE OR

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W/O:			WO	RK ORDER CHANGES	3				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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